

# Work Order ID 80263

\*80263\*

Page 1

February-15-12 3:35:11 PM

Item ID: D412-630-033

Accept

\*N9000040100\*

Setup Start

\*NS1\*

Revision ID:

Item Name: Heli Access Step LH Folding

Stop

\*NS2\*

Start Date: 15/02/2012 Start Qty: 4.00

\*4\*

Cust Item ID:

Required Date: 29/02/2012 Req'd Qty: 4.00

\*4\*

Customer:

Reference:

Approvals:

Process Plan: M.L.J

Date: 12/02/12 Tooling:

Date:

Run Start

\*NR1\*

QC:

Date: SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw:Nbr

Revision Nbr

IIN D412-630

Rev M

100

\*100\*

DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile & create labels per PPP D412-630-033 CHG003

0.00

0.00

110

\*110\*

Small Fab

Small Fab

Small Fab

Memo

Assemble as per dwg D412-630 p.14  
Coat all hardware with LPS3 rust inhibitor  
A/R LPS3 batch: M119317  
COAT exposed HARDWARE WITH LPS PROCYON.  
A/R LPS PROCYON BATCH: M114596

0.00

0.00

MLJ 12-04-3  
(4)

EP 12/04/02 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 80263****\*80263\***

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February-15-12 3:35:11 PM

Item ID: D412-630-033

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Heli Access Step LH Folding

Start Date: 15/02/2012 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 29/02/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start

**\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00

**\*120\***

QC

Memo

0.00

Quality Control

130

Pick Kit

0.00

**\*130\***

Packaging

Memo

0.00

Packaging

140

QC4- 100% Inspect kits for completeness

0.00

**\*140\***

QC

Memo

0.00

Quality Control

Sizlawy

x4  
LH

JB

12/04/03

SP

Sizlawy

x4  
LH

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**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Heli Access Step LH Folding

Start Date: 15/02/2012 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 29/02/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150		0.00							
<b>*150*</b>	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-630-033								
	Location: <u>111A</u>								
	PPP Rev: <u>A</u>								
160									
<b>*160*</b>	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

12/2/4

12/4/4

MF  
12-04-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item: D412-630-033

\*D412-630-033\*

Parent Item Name: Heli Access Step LH Folding

Start Date: 15/02/2012

Required Date: 29/02/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 06-11-08 JLM  
IPP rev B ecn 1019, added d2807-041 EC verified by:DD  
IPP rev :C 11.01.06 added route seq ID DD vef:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2012-107 *D2012-107* Clevis		Manufactured	No			110	Each	31.0000	1	4			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST004		31							
				71602		1							
				75057		30							
D2803-041 *D2803-041* Bracket Assembly		Manufactured	No			110	Each	3.0000	1	4			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST147		3							
				74804		1							
				77931		1							
				79184		1							
D2804-041 *D2804-041* Bracket Assembly		Manufactured	No			110	Each	3.0000	1	4			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST148		1							
				79181		1							
				ST149		2							
				79523		2							

\*\*

\*\*

\*\*

EB12/04/02

EB12/04/02

EB12/04/02

380256  
(4K)

380257  
(100)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item Name: Heli Access Step LH Folding

Start Date: 15/02/2012

Required Date: 29/02/2012

Start Qty: 4.00

Required Qty: 4.00

D2807-041  
\*D2807-041\*  
Door prop

Manufactured No

110 Each 15.0000 2 8

\*\*

Location	Loc Qty	Loc Code
ST018	15	
60540	2	
68494	5	
79007	8	

EP 12/04/02

B80165  
(80)

D2813  
\*D2813\*  
Washer

Manufactured No

110 Each 41.0000 2 8

\*\*

Location	Loc Qty	Loc Code
ST018	41	
69386	1	
79691	40	

EP 12/04/02

8

D3562-041  
\*D3562-041\*  
Step Assembly, LH

Manufactured No

110 Each 0.0000 1 4

\*\*

B80265 (4)

EP 12/04/02

D3395-1  
\*D3395-1\*  
Bushing

Manufactured No

110 Each 33.0000 4 16

\*\*

Location	Loc Qty	Loc Code
ST041	33	
71563	13	
78840	20	

EP 12/04/02

5

B81118  
(11)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item Name: Heli Access Step LH Folding

\*80263\*

\*D412-630-033\*

Start Date: 15/02/2012

Required Date: 29/02/2012

Start Qty: 4.00

Required Qty: 4.00

AN3C21A Purchased No  
\*AN3C21A\*  
BOLT

110 Each 66.0000 2 8

\*\*

Location	Loc Qty	Loc Code
ST352	66	
109148	2	
117514	14	
119798	50	

AN8C16 Purchased No  
\*AN8C16\*  
Bolt

110 Each 36.0000 2 8

\*\*

Location	Loc Qty	Loc Code
ST343	36	
106066	2	
118451	14	
120578	20	

AN310C8 Purchased No  
\*AN310C8\*  
Nut

110 Each 32.0000 2 8

\*\*

Location	Loc Qty	Loc Code
ST344	32	
118378	2	
120308	20	
120644	10	

MS24665-302 Purchased No  
\*MS24665-302\*  
Cotter Pin

110 Each 245.0000 6 24

\*\*

Location	Loc Qty	Loc Code
ST309	245	
117460	45	
120521	200	

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item: D412-630-033

**\*D412-630-033\***

Parent Item Name: Heli Access Step LH Folding

Start Date: 15/02/2012

Required Date: 29/02/2012

Start Qty: 4.00

Required Qty: 4.00

NAS1515H3

Purchased

No

110

Each

286.0000

4

16

**\*NAS1515H3\***

Washer

\*\*

*CP 12/04/02*

Location

Loc Qty

Loc Code

ST277

286

118078

6

118384

11

119438

4

120142

99

120518

166

*16*

NAS1515H5L

Purchased

No

110

Each

130.0000

4

16

**\*NAS1515H5I \***

WASHER

\*\*

*CP 12/04/02*

Location

Loc Qty

Loc Code

FG

40

103691

40

ST277

90

119902

90

*3*

*B121068*

*(13x)*

NAS1515H8

Purchased

No

110

Each

99.0000

4

16

**\*NAS1515H8\***

Washer

\*\*

*CP 12/04/02*

Location

Loc Qty

Loc Code

ST277

99

111275

4

111411

95

*16*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 80263

\*80263\*

Parent Item: D412-630-033

\*D412-630-033\*

Parent Item Name: Heli Access Step LH Folding

Start Date: 15/02/2012

Required Date: 29/02/2012

Start Qty: 4.00

Required Qty: 4.00

MS21043-3

Purchased

No

110

Each

1,340.000

4

16

\*MS21043-3\*

Nut

\*\*

12/04/02

## Location

## Loc Qty

## Loc Code

FG	72
103691	72
GA	400
120693	400
ST300	373
119901	373
ST301	495
118077	2
118614	441
118686	30
119758	22

16

MS24693-C280

Purchased

No

110

Each

53.0000

2

8

\*MS24693-C280\*

Screw

\*\*

12/04/02

## Location

## Loc Qty

## Loc Code

ST289	25
120498	25
ST310	28
118612	28

8

D2806-1

Manufactured

No

130

Each

43.0000

2

8

\*D2806-1\*

Bushing

\*\*

12/04/03

## Location

## Loc Qty

## Loc Code

ST018	43
78888	18
79527	25

2x 78888  
6x 79527

12/04/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item: D412-630-033

\*D412-630-033\*

Parent Item Name: Heli Access Step LH Folding

Start Date: 15/02/2012

Required Date: 29/02/2012

Start Qty: 4.00

Required Qty: 4.00

D2806-3 Manufactured No

130 Each

32.0000

2 8 ✓

\*D2806-3\*

Bushing

\*\*

23

SP

Location

Loc Qty

Loc Code

ST018

32

76187

7

79528

25

D2810-5 Manufactured No

130 Each

5.0000

79528 4

\*D2810-5\*

Strut

\*\*

79690

23

SP

Location

Loc Qty

Loc Code

ST265

5

52034

1

78917

4

D3396-1 Manufactured No

130 Each

32.0000

(2) 8 ✓

\*D3396-1\*

Spacer

\*\*

23

SP

Location

Loc Qty

Loc Code

ST041

32

78885

32

78885

12/04/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item Name: Heli Access Step LH Folding

Start Date: 15/02/2012

Required Date: 29/02/2012

Start Qty: 4.00

Required Qty: 4.00

AN4C6A

Purchased

No

130

Each

606.0000

1

4

✓

\*AN4C6A\*

Bolt

Location

Loc Qty

Loc Code

FG

4

103344

4

ST356

602

116704

8

119328

94

119749

200

120423

200

120521

100

AN4C10A

Purchased

No

130

Each

40.0000

1

4

✓

\*AN4C10A\*

Bolt

Location

Loc Qty

Loc Code

ST356

40

112243

10

114523

30

AN5C15A

Purchased

No

130

Each

71.0000

2

8

✓

\*AN5C15A\*

Bolt

Location

Loc Qty

Loc Code

ST338

71

118191

3

118267

13

119749

25

120422

30

119749

12/04/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Parent Item Name: Heli Access Step LH Folding

Start Date: 15/02/2012

Required Date: 29/02/2012

Start Qty: 4.00

Required Qty: 4.00

AN44C7A

Purchased

No

130

Each

32.0000

1

4

\*\*

**\*AN44C7A\***

Eyebolt

Location

Loc Qty

Loc Code

ST362

32

111308

32

130

Each

283.0000

2

8

\*\*

AN4C15A

Purchased

No

**\*AN4C15A\***

Bolt

Location

Loc Qty

Loc Code

ST358

283

115835

2

118706

81

120360

200

130

Each

179.0000

7

28

\*\*

NAS1515H4

Purchased

No

**\*NAS1515H4\***

Washer

Location

Loc Qty

Loc Code

ST277

179

116169

3

117460

1

117735

3

118078

48

118612

9

120120

50

120498

65

15x 120498

12/04/03

W/O:		WORK ORDER CHANGES					
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Parent Item Name: Heli Access Step LH Folding

\*80263\*

\*D412-630-033\*

Start Date: 15/02/2012

Required Date: 29/02/2012

Start Qty: 4.00

Required Qty: 4.00

NAS1515H5

Purchased

No

130

Each

298.0000

7

28

✓

\*NAS1515H5\*

Washer

\*\*

JB [Signature]

Location

Loc Qty

Loc Code

FG

25

103286

5

103691

20

GA

100

120449

100

ST277

173

120299

73

120304

100

2X 120299

26X 120304

4

16

✓

\*\*

JB [Signature]

MS21043-4

Purchased

No

130

Each

1,773.000

\*MS21043-4\*

Nut

Location

Loc Qty

Loc Code

FG

40

104603

40

ST300

288

118686

288

ST301

1445

119546

445

120308

1000

120308

12/04/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID: 80263

**\*80263\***

Parent Item: D412-630-033

**\*D412-630-033\***

Parent Item Name: Heli Access Step LH Folding

Start Date: 15/02/2012

Required Date: 29/02/2012

Start Qty: 4.00

Required Qty: 4.00

MS21043-5

Purchased

No

130

Each

547.0000

3

12

\*\*

**\*MS21043-5\***

Nut

Location

Loc Qty

Loc Code

FG

20

101418

20

ST300

102

112314

102

ST301

425

116548

100

118159

100

119307

25

119537

200

112314

12/04/03

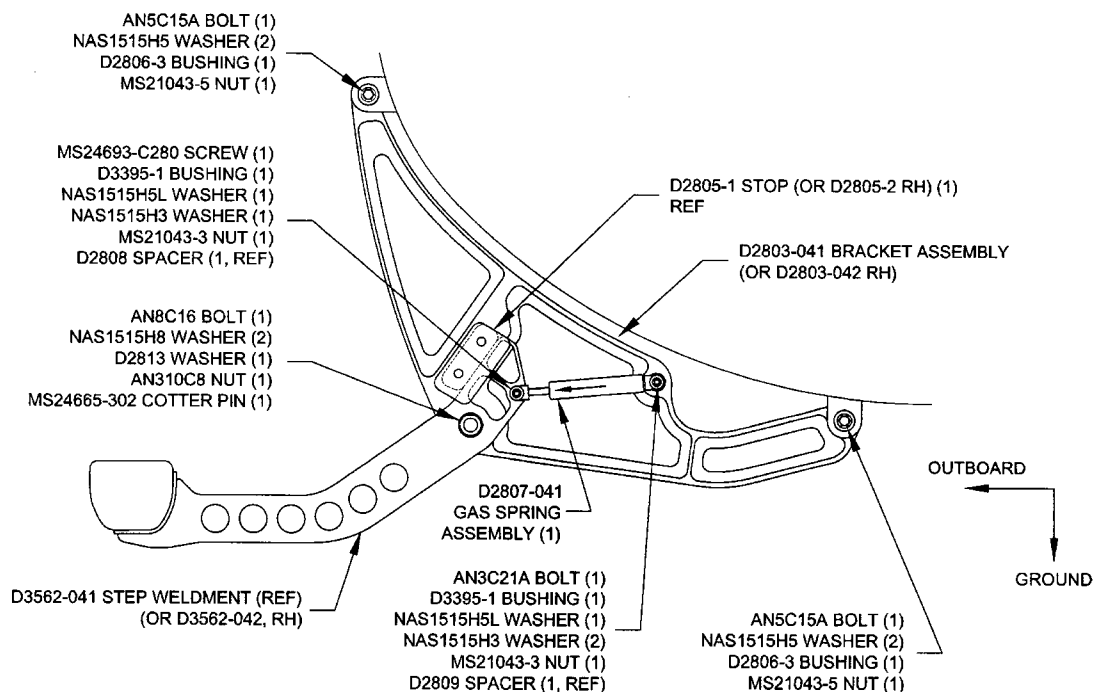
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

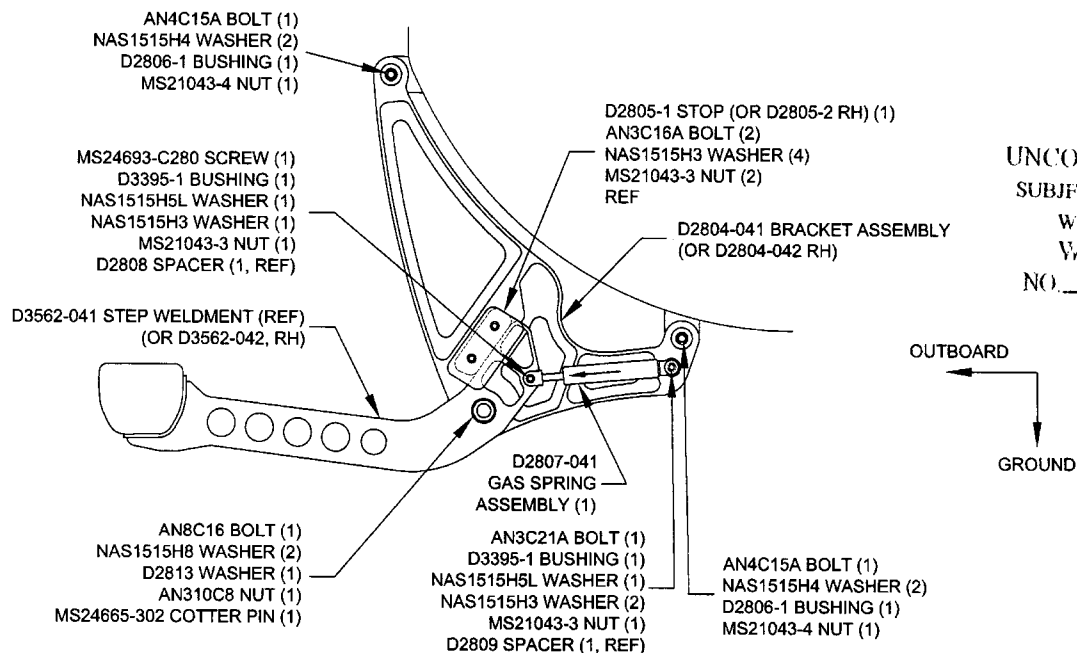
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**D412-630-033/-034 Heli-Access-Step™ Installation**

**FIGURE 14 – STA 84.29 for D412-630-033/-034 Heli-Access-Step™ Installation**  
(View rotated 90° CW)



**FIGURE 15 – STA 155.06 for D412-630-033/-034 Heli-Access-Step™ Installation**  
(View rotated 90° CW)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 80263  
M.C.J.  
12/02/16

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Revision: **M**  
Date: 08.12.12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

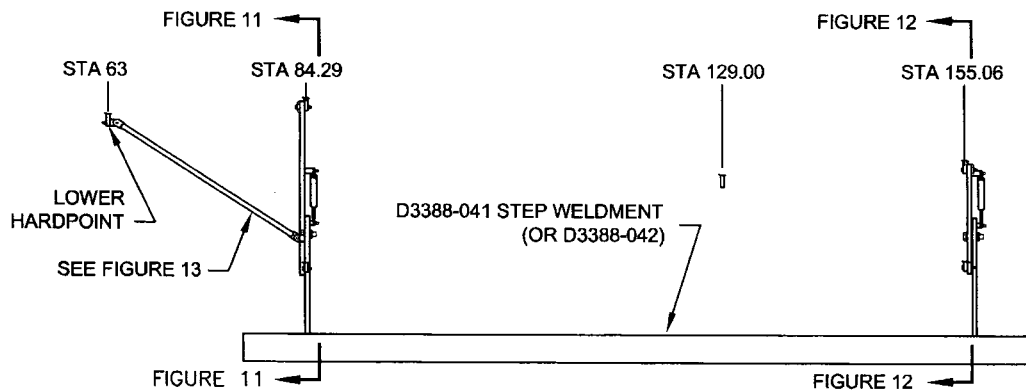
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

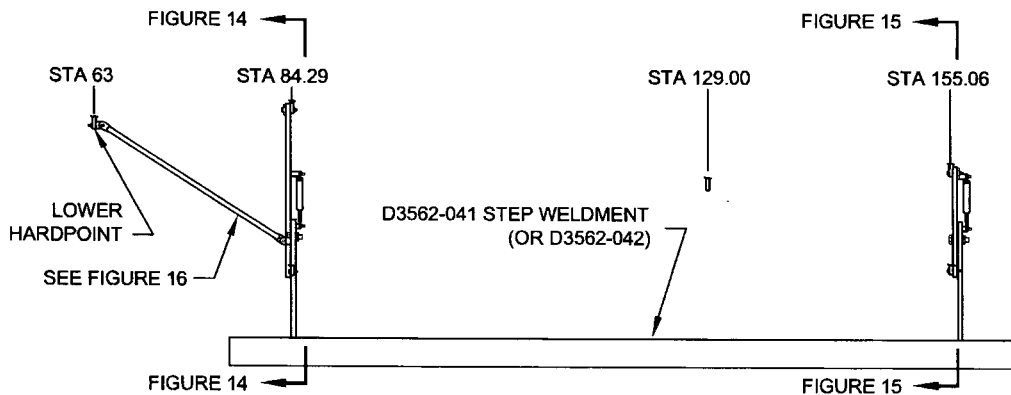
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

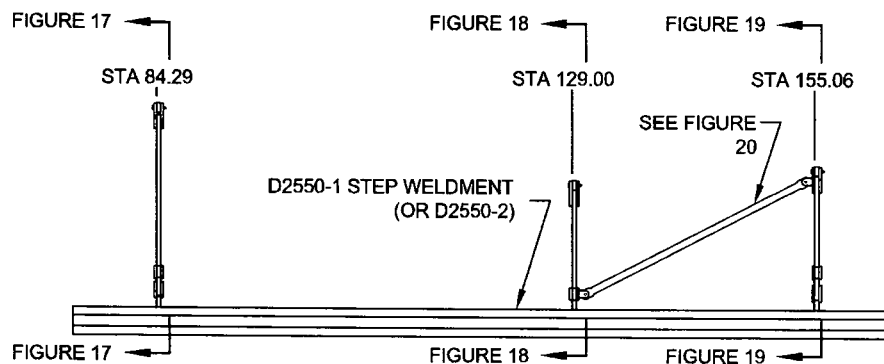
**D412-630-023 HELI-ACCESS-STEP™ LH, FOLDING (SHOWN)**  
**D412-630-024 HELI-ACCESS-STEP™ RH, FOLDING (OPPOSITE)**



**D412-630-033 HELI-ACCESS-STEP™ LH, FOLDING (SHOWN)**  
**D412-630-034 HELI-ACCESS-STEP™ RH, FOLDING (OPPOSITE)**



**D412-630-111 HELI-ACCESS-STEP™ LH, HEAVY DUTY FIXED (SHOWN)**  
**D412-630-112 HELI-ACCESS-STEP™ RH, HEAVY DUTY FIXED (OPPOSITE)**



**FIGURE 3 – D412-630 Heli-Access-Step™ Installations**

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Revision: **M**  
Date: 08.12.12

Qty -033	Qty -034	Qty -243	Qty -244	Part Number	Description
X				D412-630-033	HELI-ACCESS-STEP™ LH (FOLDING)
	X			D412-630-034	HELI-ACCESS-STEP™ RH (FOLDING)
1		X		D412-630-243	STEP ASSEMBLY LH
	1		X	D412-630-244	STEP ASSEMBLY RH
		1	1	D2012-107	CLEVIS
		1		D2803-041	STA 84 BRACKET ASSEMBLY LH
			1	D2803-042	STA 84 BRACKET ASSEMBLY RH
		1		D2804-041	STA 155 BRACKET ASSEMBLY LH
			1	D2804-042	STA 155 BRACKET ASSEMBLY RH
2	2			D2806-1	BUSHING
2	2			D2806-3	BUSHING
		2	2	D2807-041	GAS SPRING ASSEMBLY (WAS D2807)
1	1			D2810-5	STRUT
		2	2	D2813	WASHER
		1		D3562-041	STEP WELDMENT LH
			1	D3562-042	STEP WELDMENT RH
		4	4	D3395-1	BUSHING
2	2			D3396-1	SPACER
		2	2	AN3C21A	BOLT
1	1			AN4C6A	BOLT
1	1			AN4C10A	BOLT
2	2			AN4C15A	BOLT
1	1			AN44-C7A	EYEBOLT
2	2			AN5C15A	BOLT
		2	2	AN8C16	BOLT
		2	2	AN310C8	NUT
		2	2	MS24665-302	COTTER PIN (OR AN380C3-4)
		6	6	NAS1515H3	WASHER
7	7			NAS1515H4	WASHER
7	7			NAS1515H5	WASHER
		4	4	NAS1515H5L	WASHER
		4	4	NAS1515H8	WASHER
		4	4	MS21043-3	NUT
4	4			MS21043-4	NUT
3	3			MS21043-5	NUT
		2	2	MS24693-C280	SCREW (OR MS24694-C565)

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